

Work Order ID 66251

February 8, 2011 10:05:45 AM



Page 1

Item ID: D2938-1

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 2/08/11

Start Qty: 6.00

Required Date: 2/22/11

Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: CL

Date: 11/02/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.1.14		DIMENSIONS .063" AND .270 / .240" HIGHLIGHTED ON DRAWING ARE .008" AND .005" UNDER TOLERANCE RESPECTIVELY. OFFSET ENTRY ERROR, OFFSET ENTERED TO LATE FOR CONTROL TO READ. OPERATOR ERROR SADDLE #2.			11.1.14			

NOTE: Date & initial all entries

Work Order ID 66251

February 8, 2011 10:05:45 AM



Page 2

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 2/08/11

Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

and 11/03/04

5

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7m-l 11/03/04

(SX)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M115951

320 OF

7m-l 11/03/04 (SX)

START TIME:

OVEN TEMPERATURE:

9:00 FINISH TIME:

9:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66251

February 8, 2011 10:05:45 AM



Page 3

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 2/08/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5	4	22	116364
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>403A</u> Memo	0.00 0.00				11/3/11	SL	50	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				CK	11/03/04	MF	11-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 10:05:44 AM

Page 1

Work Order ID: 66251



Parent Item: D2938-1



Parent Item Name: Saddle LH Out, 206

Start Date: 2/08/11


Required Date: 2/22/11

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	30.0000	1	6			

al 11-3-1

Location

Loc Qty

Loc Code

MAT

20

65151

20

MAT042

10

65175

10

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

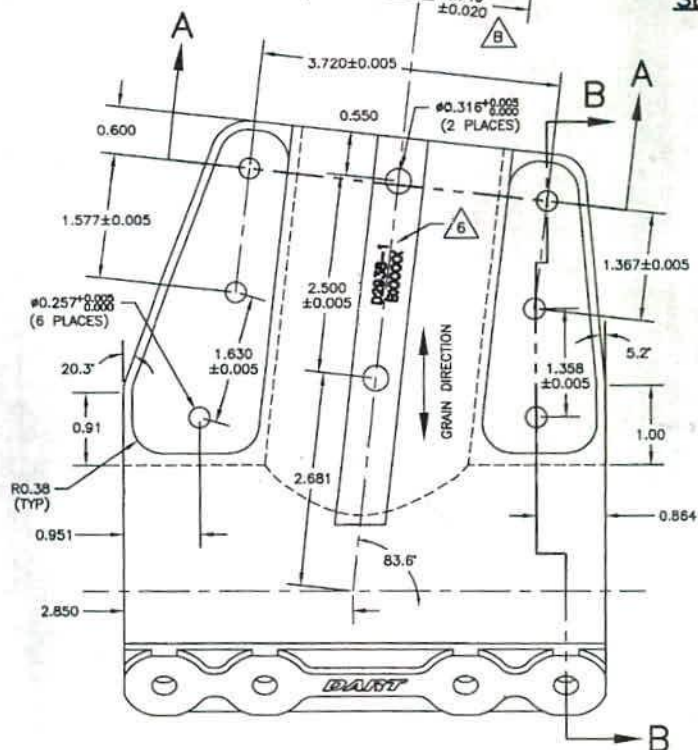
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

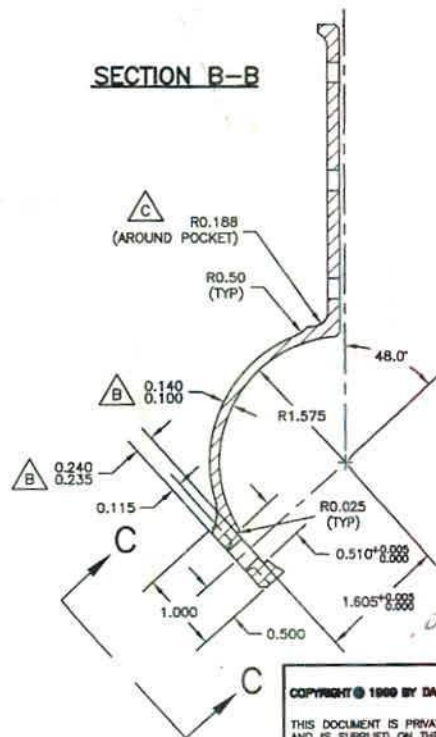
NOTE: Date & initial all entries



SECTION A-A

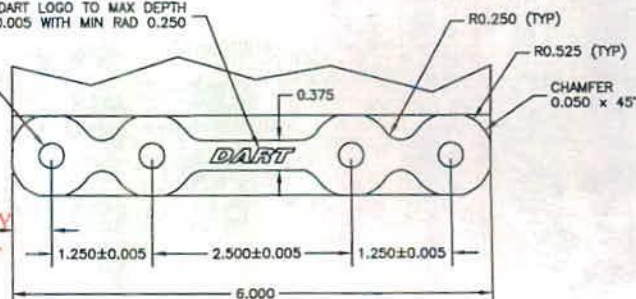


SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250

0.312 ±0.005
(4 PLACES)



VIEW C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66251
C 21102108

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM 06101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 1990 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

07.02.12

DART AEROSPACE LTD	Work Order: 66251
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.128				
B	0.100	0.140		.127	.130				
C	0.100	0.140		.135	.135				
D	0.210	0.230		.223	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.112	.111				
O	0.540	0.560		.548	.549				
P	0.490	0.510		.495	.496				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.742	2.742				
S	0.240	0.270		.250	.252				
T	0.100	0.180		.127	.127				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.262	1.261				
Y	1.565	1.585		1.574	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 11.3.1

Audited by: <i>[Signature]</i>
Date: 11/03/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 66251
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.128	.117	.127	.130		
B	0.100	0.140		.119	.110	.127	.125		
C	0.100	0.140		.135	.121	.135	.128		
D	0.210	0.230		.224	.224	.222	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.312	.313	.313	.313		
M	0.235	0.240		.237	.238	.238	.238		
N	0.100	0.140		.113	.128	.128	.113		
O	0.540	0.560		.548	.548	.548	.550		
P	0.490	0.510		.505	.501	.501	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.744	2.742	2.742	2.742		
S	0.240	0.270		.251	.235 *	.250	.251		
T	0.100	0.180		.127	.127	.127	.127		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.263	1.278 *	1.262	1.263		
Y	1.565	1.585		1.578	1.588 *	1.575	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

RQ.02

RQ.06
RQ.02

RQ.09
RQ.09

Measured by: <i>ML</i>
Date: 11.3.1

Audited by: <i>ML</i>
Date: 11/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>